

Wednesday, 6/28/2006 4:09:43 PM
m Johnston

Process Sheet

Split 11/06-11-20

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BO 105 SKIDTUBE ASSEMBLY
 Job Number : 27722-1
 Estimate Number : 10112
 P.O. Number : N/A
 This Issue : 6/28/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LANDING GEAR
 Previous Run : 22369
 Part Number : D105674011G
 Drawing Number : D2966 REV A2
 Project Number : N/A
 Drawing Revision : A2
 Material : N/A
 Due Date : 7/5/2006 Qty: ② Um: Each
 Written By :
 Checked & Approved By : 06 06 29
 Comment : Est Rev: A 04.07.07 New Issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP d105-674-011G CHG002

KS 06 06 30

2.0 D2962125 3.540 Outer Tube, Extrud



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2962-125 Extrusion

B12532

DP 6-11-14
DP 6-8-80 ③
6-7-100

3.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Open holes to Ø5/16" (0.313"). Deburr holes.

DP 6-11-14
DP 6-8-80 ①
6-7-100

4.0 BENDING BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per program BO105 on CNC Bender and Dwg D2966. Use 5/16" locator pin on buggy "A".

DP 6-11-14
6-7-10 ①

5.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut Fwd end of the tube using DT8185-1G

DP 6-11-14 ①
DP 6-7-10 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR: 27722-1		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-07-21	3.0 6.0	Middle hole dims. are under tolerance. Hole spacing unacceptable. Tube scrap AS per attached e-mail.	CP 06.07.21 per QSI 042	destroy: replace tube verify sig dimensions. original qty was	CP 06-11-20	CP 06-11-20	CP 06.07.21 per QSI 042	CP 06-07-21

Part No: D105-674-0116 PAR #: N/A

Fault Category: Prod/Inspection REAR

NCR: Yes No DQA: Yes

Date: 06/11/21

NOTE: Date & initial all entries

QA: N/C Closed: Yes

Date: 06.11.21

Date: Wednesday, 6/28/2006 4:09:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 27722

Part Number: D105674011G

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut Aft end at 107.06" using DT8185D

3-Deburr ends

4-Drill Aft Cap holes using DT8678

5-Locate DT8679 with 1/8 clecos in Aft Cap holes. Ensure DT8679 is centered on Fwd end of tube and drill #40 Fwd bushing.

6-Clamp DT8679 to the tube. Drill all #30 wearplate and crossbolt holes.

7-Open Aft Cap holes using #6 drill

8-Open wearplate holes and two side holes to Ø19/64" (0.297") as per Dwg D2966-1.

9-Deburr holes.

10-Open remaining (16) crossbolt holes to Ø0.500

6.0

D2964

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2964

Cap

A/R

Aluminum Rod

3-14101

m100660

BE 06-07-10

BE 06-11-15

3

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D2966 and QSI 004. Fill #40 Fwd cleco hole.

2-Grind Fwd Cap welds flush

BE 06-07-10

BE 06-11-15

BE 06-07-10

8.0

QC5/9

WELD INSPECTION



Comment: INSPECT WELDS & WORK TO CURRENT STEP.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 27722

Part Number: D105674011G

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: YL 06/11/15 x2

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: DP 6-11-15 (2)

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to finish size as per Dwg D2966

2-Open 14 holes to Ø0.750" & 2 holes to Ø0.875", countersink crossbolt holes & remove alodine to prepare for welding as per Dwg D2966

3-Deburr holes inside & outside, blow out chips

Handwritten: PTO Split
DP 6-11-15 (1)

12.0

D2976

BO 105 Skidtube I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Numbe Description Batch

1 D2976 Web

Handwritten: B27742

Handwritten: DP 6-11-15 (1)

13.0

D2971

Cross Bolt Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2971 Crossbolt Spacer

Handwritten: 218997 BE 6-11-17

14.0

D2973

Cross Bolt Spacer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pick:

Qty Part Number Description Batch

7 D2973 Crossbolt Spacer

Handwritten: B14636 BE 6-11-17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
	11.0	SPLIT W/O for 1 tube. 1 tube remaining on the other W/O.					<i>[Signature]</i> 06-11-20	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
	4							

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 27722

Part Number: D105674011G

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bond Web in place per QSI 015. (Ensure holes line up)

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 M102660

Sikaflex expiry date: 02-2-1

DP 06-11-17

2-Weld Crossbolt Spacers as per Dwg D2966 and QSI 004. For crossbolt spacer, weld one side, pass 5/8" drill; weld other side, pass 5/8" drill.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod M101655 BE 06-11-17

3-Pass Ø0.630" drill to remove spillover for D2973 crossbolt. Pass Ø0.750" drill to remove spillover for D2971 crossbolt.

BE 06-11-17

4-Grind welds flush as per Dwg D2966

BE 06-11-17

16.0

QC5/9

WELD INSPECTION



Comment: Inspect welds and work to Current Step
Inspect for foreign objects as per QSI 024

Jan 11 2000
06/11/20 @

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

06/11/20 x1

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 11 20 ①

19.0

D2965

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2965 Cap 19772

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/28/2006 4:09:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 27722

Part Number: D105674011G

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D29701

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2970-1 Wearplate

~~14590~~ 14589

21.0

D29703

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2970-3 Wearplate

12322

22.0

D31761

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3176-1 Bushing

25028

23.0

D31763

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3176-3 Nut

25029

24.0

ALS71032130

Insert



Comment: Qty.: 36.0000 Each(s)/Unit Total: 36.0000 Each(s)

Pick:

Qty Part Number Description Batch

36 ALS7-1032-130 Insert

or ALS4-1032-130

or AKS7-1032-130

or AKS4-1032-130

18990

FC 06 11 20 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 27722

Part Number: D105674011G

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

AN960JD10L

Washer



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Pick:

Qty Part Number Description Batch

28 AN960JD10L Washer 100233

26.0

MS27039108

Screw



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick:

Qty Part Number Description Batch

26 MS27039-1-08 Screw 102404

27.0

MS27039109

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

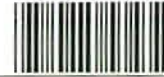
Qty Part Number Description Batch

2 MS27039-1-09 Screw 8912

28.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for foreign objects as per QSI 024

FC

2-Install Inserts, Wearplate and Cap per Dwg D2966. Insert a drop of sikaflex at insert holes before installing, wearplates. Seal Aft Cap using Sikaflex. Install bushing and nut. By looking Fwd, install nut to right hand side.

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 102057

Sikaflex expiry date: 02/07

FC

3-Wing Walk as per Dwg D2966 and QSI 005 4.4

Batch: 102635

FC

06 11 21

①

W/O:		WORK ORDER CHANGES					
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 27722

Part Number: D105674011G

Job Number:



Seq. #:	Machine Or Operation:	Description :
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29.0	QC3/5	INSPECT WORK/WING WALK
------	-------	------------------------



Comment: INSPECT WORK/WING WALK

AD06/11/21 (1)

30.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

31.0	D2972	Bushing
------	-------	---------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2972 Bushing

14103

32.0	D2974	Packer
------	-------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2974 Packer

B29439

33.0	D2975	Wearplate
------	-------	-----------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2975 Wearplate

B20829

34.0	AN451A	Bolt
------	--------	------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

3 AN4-51A Bolt

M101389 PASS RT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BO 105 SKIDTUBE ASSEMBLY

Job Number: 27722

Part Number: D105674011G

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN960JD10L Washer

M10291

36.0

MS21042L4

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

3 MS21042L4 Nut

M19185

37.0

MS27039108

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 MS27039-1-08 Screw

M102537

Rev A 6/21/21 (1)

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Rev A 6/21/21 (1)

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per RPP D105-674-011G

Location:

Rev A

Rev A 6/21/21 (1)

40.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Rev A 6/21/21 (1)

Job Completion



Rev A 6/21/21

W/O:		WORK ORDER CHANGES					
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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2966	REV. A SHEET 1 OF 2
DATE 00.03.08		TITLE BO 105 SKIDTUBE ASSEMBLY	SCALE NTS
A	00.03.08	NEW ISSUE	

RELEASED
00.05.11 [Signature]

Qty	Part Number	Description
X	D2966-041	SKIDTUBE ASSEMBLY
1	D2962-125	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2970-1	WEARPLATE
1	D2970-3	WEARPLATE
1	D2971	CROSS BOLT SPACER
7	D2973	CROSS BOLT SPACER
1	D2976	WEB
36	ALS7-1032-130 or ALS4-1032-130 or AKS7-1032-130 or AKS4-1032-130	INSERT
28	AN960JD10L	WASHER
26	MS27039-1-08	SCREW
2	MS27039-1-09	SCREW
1	D3176-1	BUSHING
1	D3176-3	NUT

A2**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELDING TO BE DONE PER DART QSI 004.
- 3) INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/ -291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8451 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION B-B (34 PLACES) AFTER FINISH. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 5) DO NOT INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN THESE LOCATIONS.
- 6) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND AN960JD10L WASHER IN 2 PLACES THIS LOCATION BEFORE POWDER COATING.
- 7) FINISH:

ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2976 WEB
POWDER COAT ASSEMBLY ~~GLOSS WHITE~~ (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART
QSI 005 4.4 (OPTIONAL) BLACK SANDTEX (REF 4.3.5.7)

01.01.29
01.01.30

A1

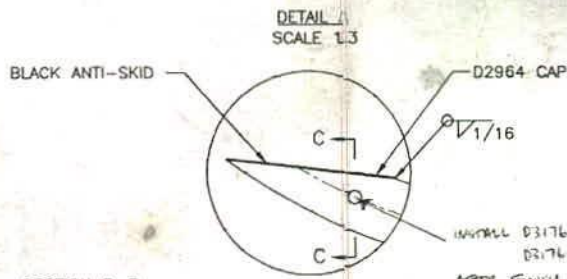
SHOP COPY
SUBJECT TO
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27722

A2	02.10.30	ADD D3176-1/-3	[Signature]
A1	01.01.29	CHANGE COLOR TO BLACK SANDTEX	[Signature]

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SECTION B-B
SCALE 1:6

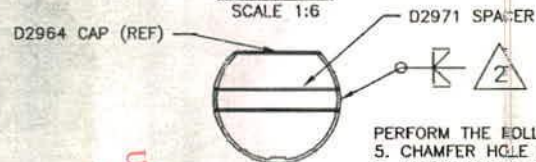


- 4
- ALS7-1032-130 INSERT (34 PLACES)
- 4
- MS27039-1-08 SCREW (1)
AN960JD10L WASHER (1)
(26 PLACES)

AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.750$ HOLES ONLY:

1. CHAMFER HOLE $0.030 \times 45^\circ$
2. INSERT D2973 SPACER (7 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS $\phi 0.630$ DRILL TO REMOVE SPILL OVER

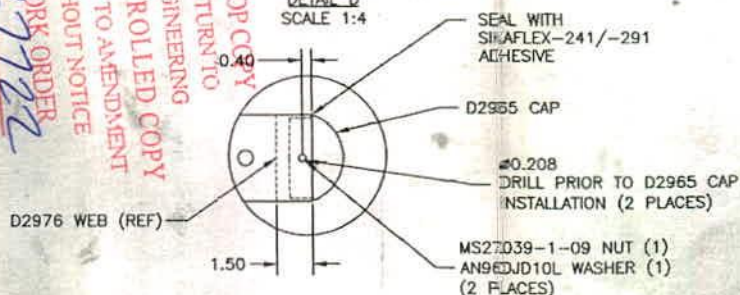
SECTION C-C
SCALE 1:6



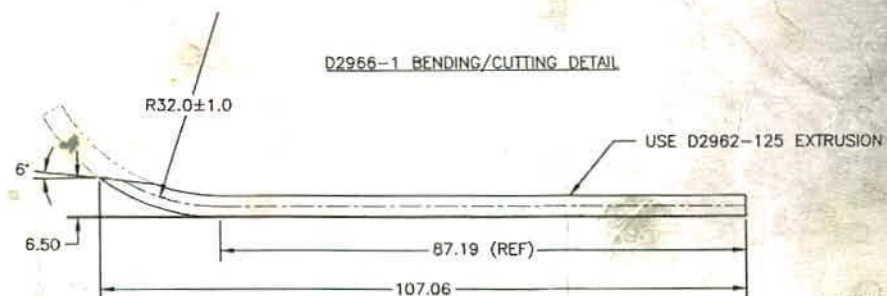
5. CHAMFER HOLE $0.030 \times 45^\circ$

6. INSERT D2971 SPACER
7. WELD INTO PLACE AND GRIND FLUSH
8. PASS $\phi 0.484$ DRILL TO REMOVE SPILL OVER

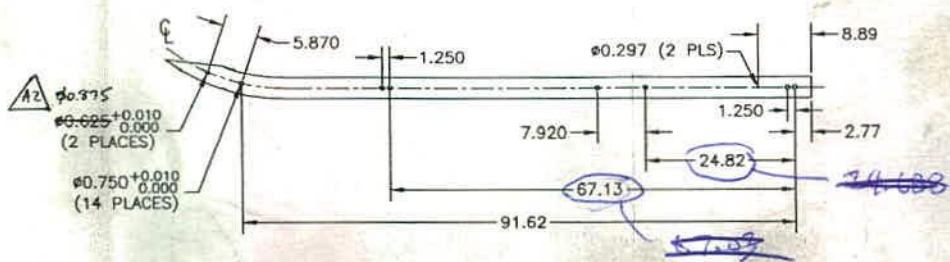
DETAIL D
SCALE 1:4



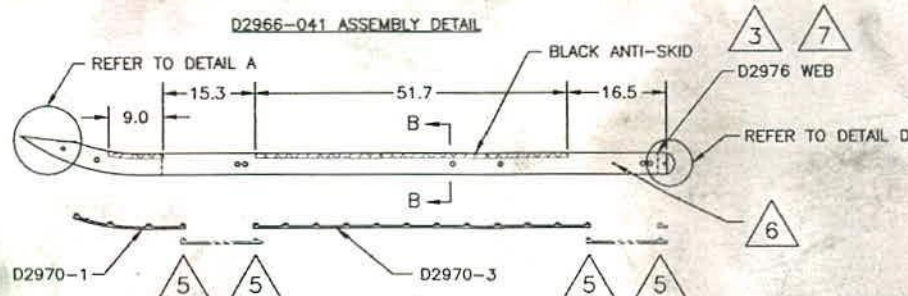
D2966-1 BENDING/CUTTING DETAIL



D2966-1 DRILLING DETAIL



D2966-041 ASSEMBLY DETAIL



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DART AEROSPACE USA, INC.

DESIGN RF	DRAWN BY RF	DART DART AEROSPACE USA, INC. BELLINGHAM, WA	REV. A
CHECKED A	APPROVED A	DRAWING NO. D2966	SHEET 2 OF 2
DATE 00.03.08	TITLE BO 105 SKIDTUBE ASSEMBLY	SCALE 1:20	

NO. 27722

WORK ORDER

SUBJECT TO AGREEMENT

UNCONTROLLED COPY

ENGINEERING

RETURN TO

SHOP COPY

RELEASED
00.05.11

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: July 11, 2006 3:30 PM
To: 'Chris Provencal'
Subject: RE: NCR BO 105 Skidtube

The fwd group of holes is for floats. Distance to aft group is critical and 0.100" is quite a bit out. Although it might work, I would be tempted to cut our losses and scrap this tube. We would probably spend more money trying to figure out if it would work or not.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Tuesday, July 11, 2006 12:25 PM
To: David Shepherd (David Shepherd)
Cc: 'Serge Shahbazian'; jmurdoch@dartaero.com
Subject: NCR BO 105 Skidtube

David,

For the D2966-041 BO105 skidtube, two groups of holes are offset by 1/8". One group looks like ground handling, and is probably not too critical. Not sure what the fwd group is for. Is this acceptable?

Chris

NO. 77

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliot
Joint Welding Procedure tig
Part number and Job number D905 674 01 G / B27722

TEST WELDS REQUIRED

BASE METAL Alum. WELDING PROCESS tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into N/A Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 6-11-17 Qualifier P. J. D.

S Shahbazian

From: David Shepherd [dshepherd@dartaero.com]
Sent: November 17, 2006 12:04 PM
To: 'S Shahbazian'
Subject: RE: B105 skidtube

You are correct. These holes are for the floats.
If they were at 0.188" size still, I would have suggested plugging and re-drilling.
However, given that they are almost full size, I recommend leaving as is.
You must respect the 1.250 dimension, but I think the 67.06 dimension is an acceptable deviation.

David

From: S Shahbazian [mailto:sshahbazian@dartaero.com]
Sent: Friday, November 17, 2006 9:48 AM
To: Shepherd, David
Subject: B105 skidtube

David,

There is a B105 skidtube that manufacturing has made an error. The dimension 67.13 shown on attached drawing is 67.062 now. I looked at the installation and I could not see what are those holes are for (maybe floats). Do you think if that is ok? Is it acceptable?

Serge

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17/11/2006